

# Work Order ID 66036

Wednesday, February 02, 2011 2:22:34 PM

Page 1

Item ID: D4306-044

Accept

Revision ID:

Item Name: Rib Assembly, RH

Setup Start

Stop

Start Date: 2/2/2011 Start Qty: 1.00

Required Date: 2/3/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4306

B

100

Weld per dwg A/R S.S. rod Batch: 111585 0.00



Large Fab

Large Fab

Memo

11.02.02

0.00

1- Cut tube 50" 55" SAD

2- Bend tube with manuel pipe bender as per DT9567 SAD

\*\*\* Make line at 0.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\* SAD

3- Trim access tube material to finish size and cut notch as per dwg D4306-4 SAD

4- Drill and chamfer holes as per dwg D4306-4 using DT9710 SAD 11-02-02

5- weld bushing as per dwg D4306

6- grind welds flush

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sad 02/03

Pl 11.02.03

①

⑦

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Page 2

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Setup Start



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Start Date: 2/2/2011 Start Qty: 1.00



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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*8/12/10*

*(H)*

*PL 11-02-03*

*1X*

*11/02/04*  
*MF*  
*11-02-03*

# Picklist Print

Wednesday, February 02, 2011 2:22:32 PM

Page 1

Work Order ID: 66036

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH



Start Date: 2/2/2011

Required Date: 2/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1  
Bushing

Manufactured No

100

Each

9.0000

4

4

Location

Loc Qty

Loc Code

WA

9

54072

9

M304TS0.750W.049

Purchased

No

100

f

198.5367

4.166

4.385263



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

161.5908679

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

25.1993

116509

19.3317

116712

108.9095

MAT017

3.68448E-05

114298

3.6845E-05

WA

36.9458

114992

11.0693

115260

25.8765



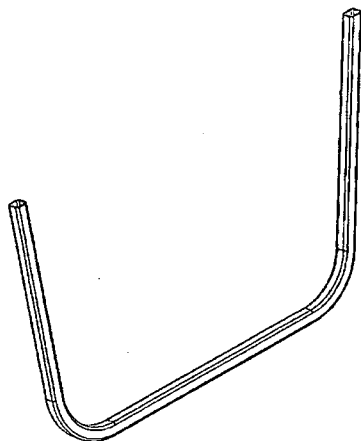
11-02-03

365709 → (4)

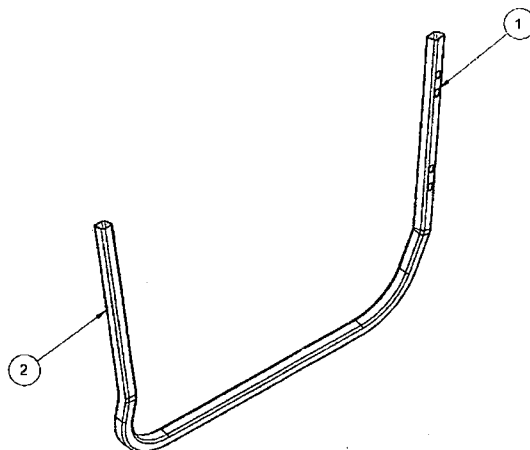
SAD 11-02-02

4.3853

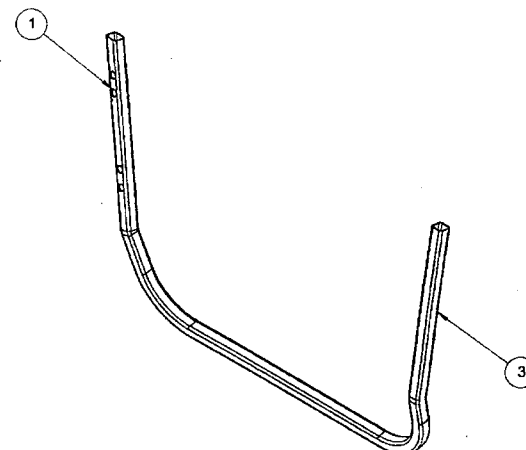
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	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



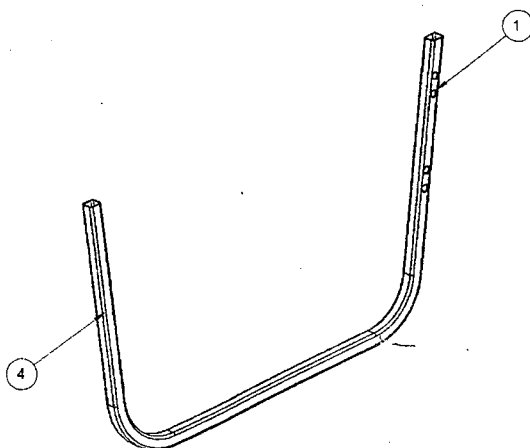
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**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**

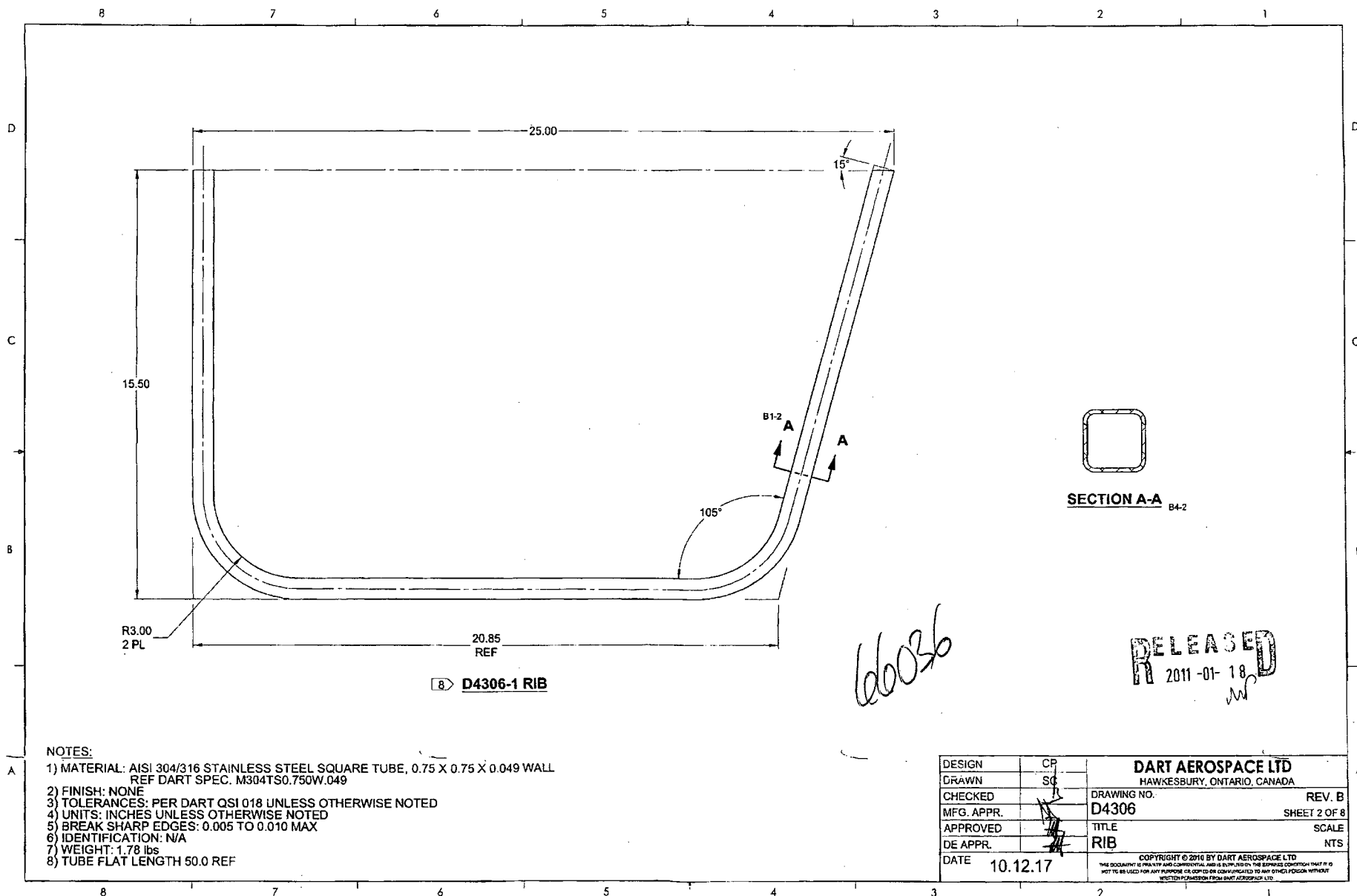


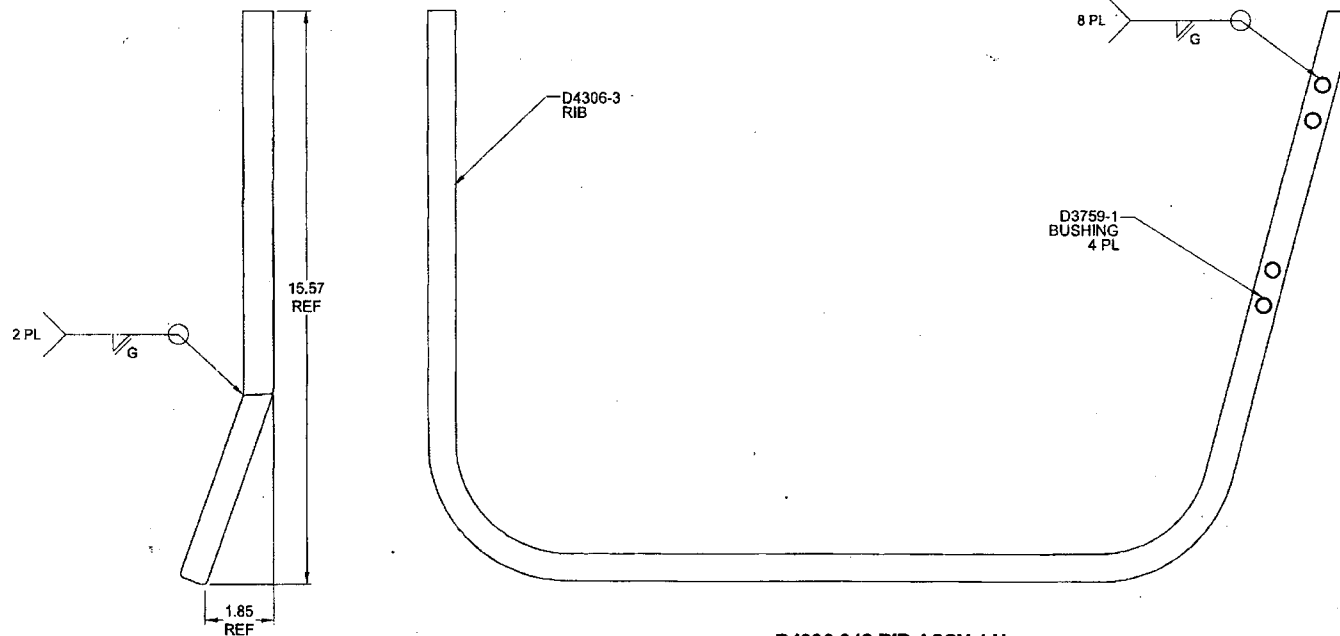
**D4306-045 RIB ASSY**

*also 66034*

**RELEASED**  
2011-01-18  
*MP*

B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4306	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB	NTS
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**D4306-043 RIB ASSY, LH**

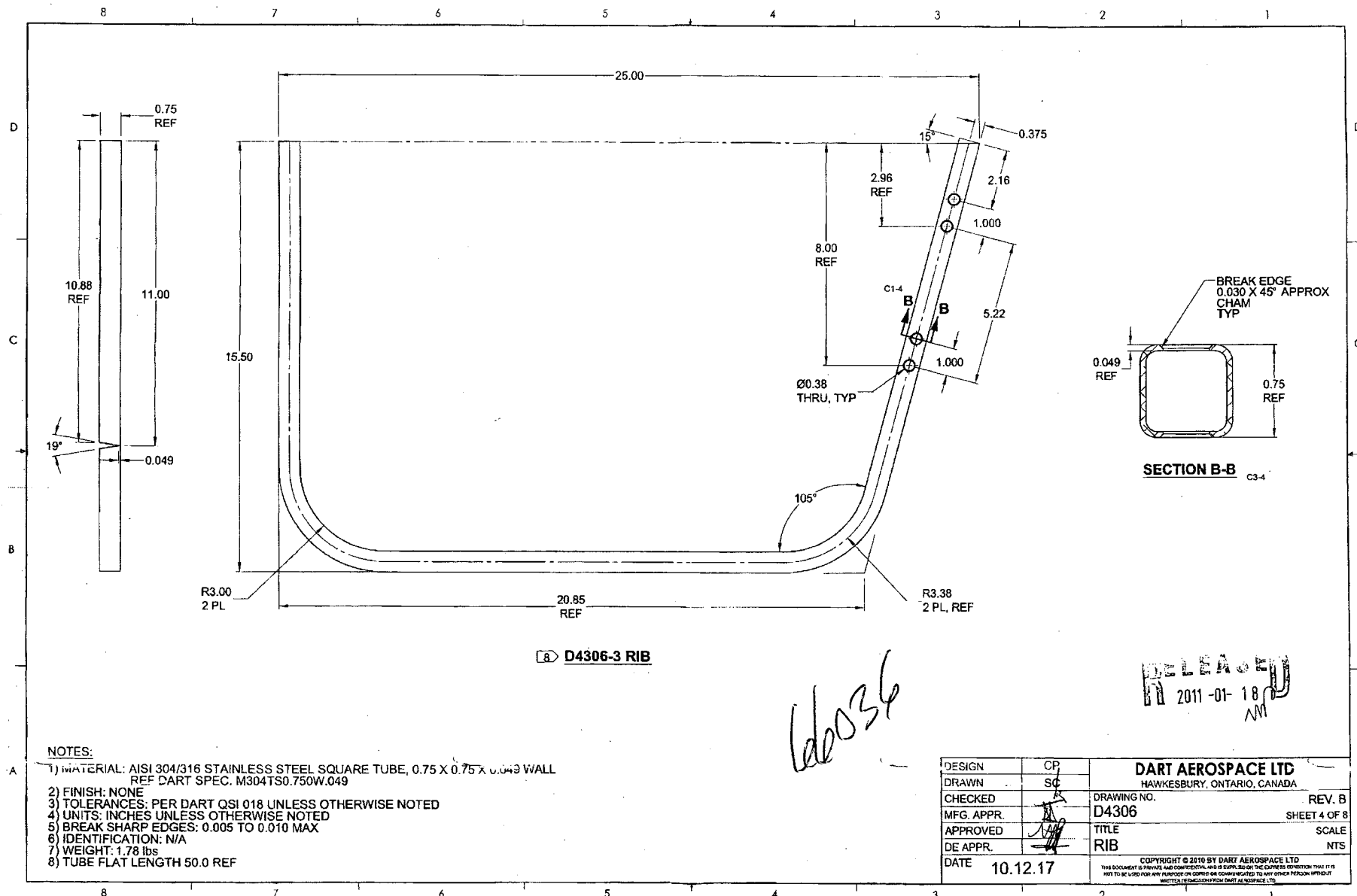
*660340*

**RELEASED**  
2011-01-18  
*AM*

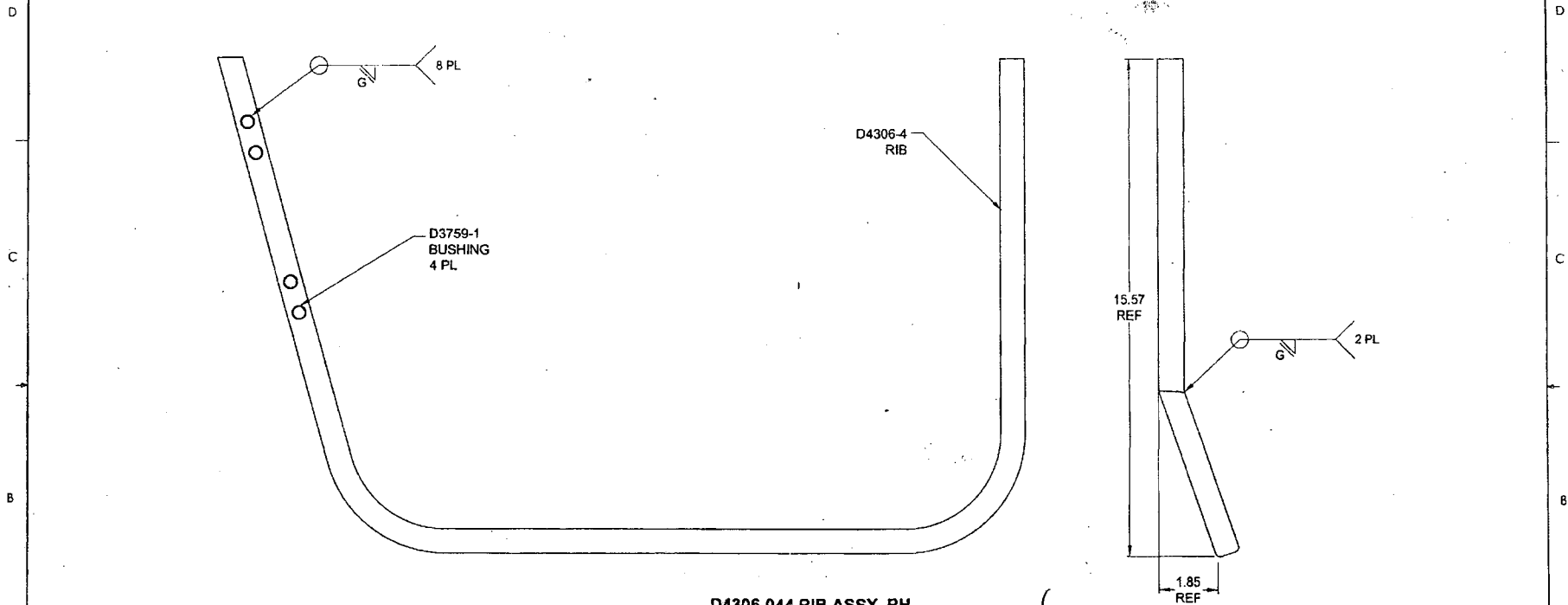
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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8 7 6 5 4 3 2 1



**D4306-044 RIB ASSY, RH**

*66036*

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2011-01-18  
JN

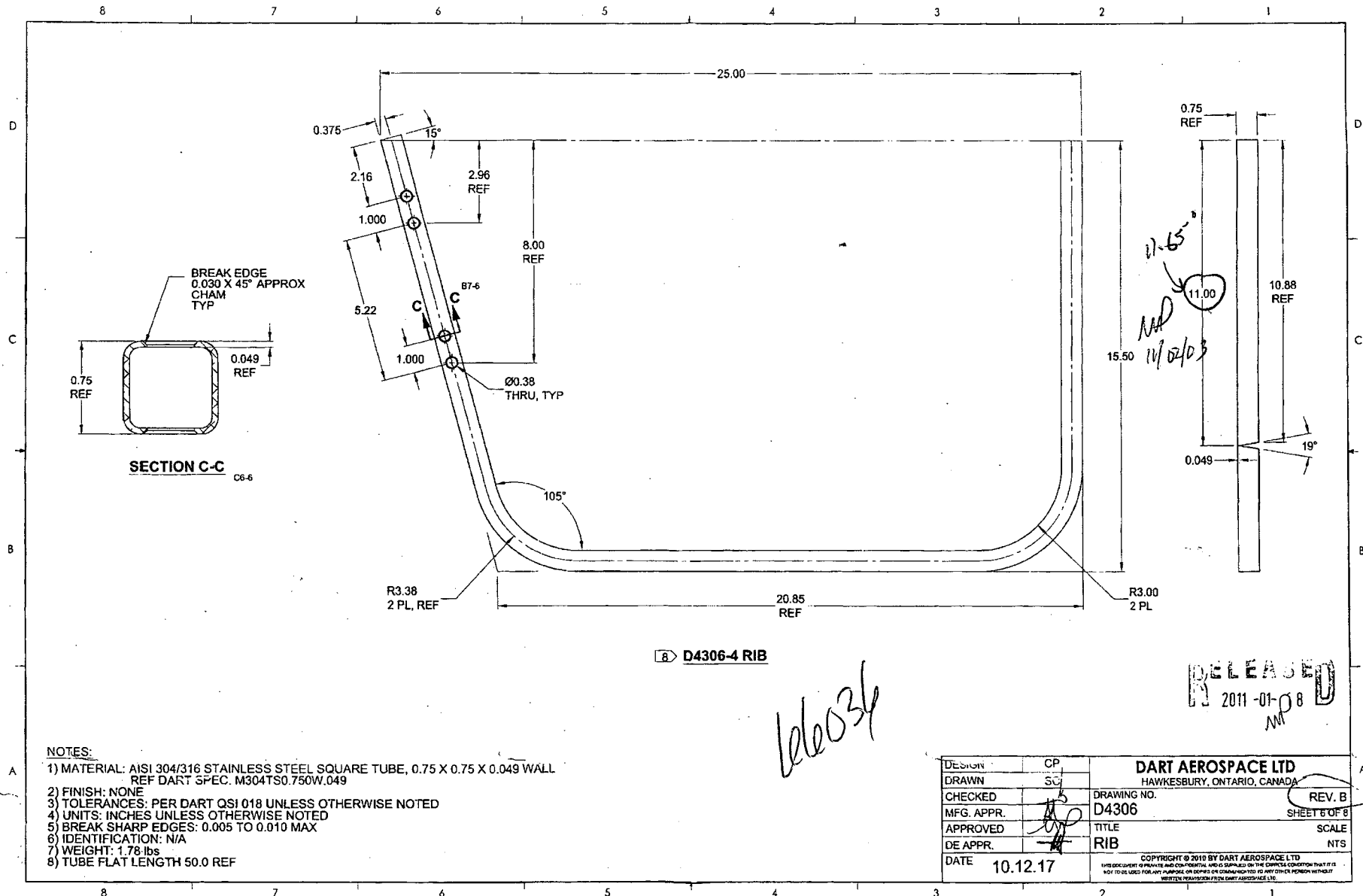
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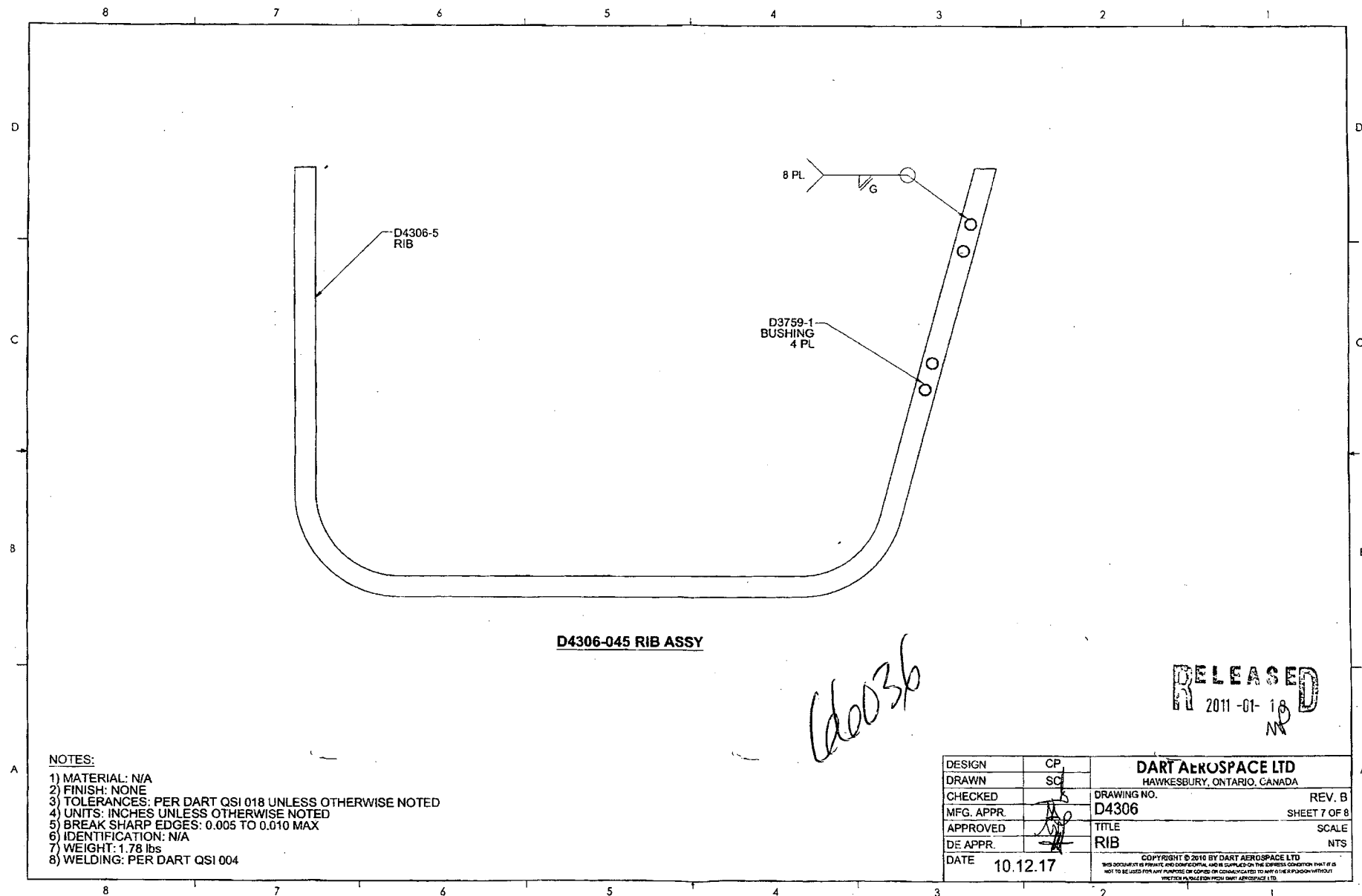
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8 7 6 5 4 3 2 1







**D4306-045 RIB ASSY**

**RELEASED**  
2011-01-18  
NR

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